

Date: Tuesday, 11/11/2008 12:46:05 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 43313		
Estimate Number	: 11019		
P.O. Number	:	Part Number	: D27313
This Issue	: 11/11/2008 S.O. No. :	Drawing Number	: D2731 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39441	Material	:
Written By	:	Due Date	: 05/12/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>JUD 08.11.11</u>		
Comment	: Est:D 00.05.19 Added inspect level 8, removed P/O for powder coating EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 3.5858 f(s)
Lug Extrusion D2423
Batch: 7 43722

cut @ meter

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut D2423 Extrusion: 0.82" Long

meter
use P/O 7572

cut @ meter

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per folio D2731-3
Check for crack while loading into the machine
Tumble Deburr any rough edges after tumbling

machine as per folio D2731-3

REV. B

CD 08/11/13

(50)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

read + inspect
attached CofC

PC 9/01/13 (51)

5.0	QC3	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 02/01/09 (451)

coupler

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/11/2008 12:46:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 43313

Part Number: D27313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(51)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/01/12

7.0

POWDER COATING

POWDER COATING



m 109996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(51)

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FL 09/01/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ell

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-13 (51)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(51x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 469

9/1/15

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

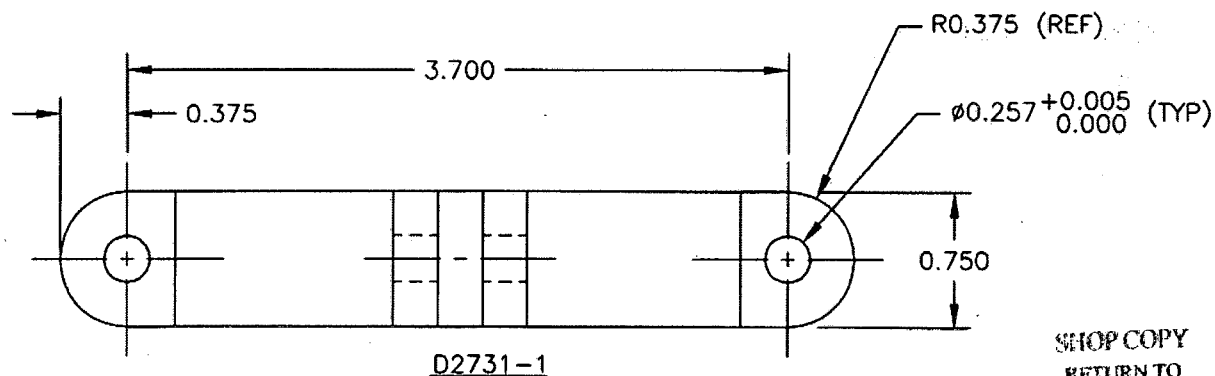
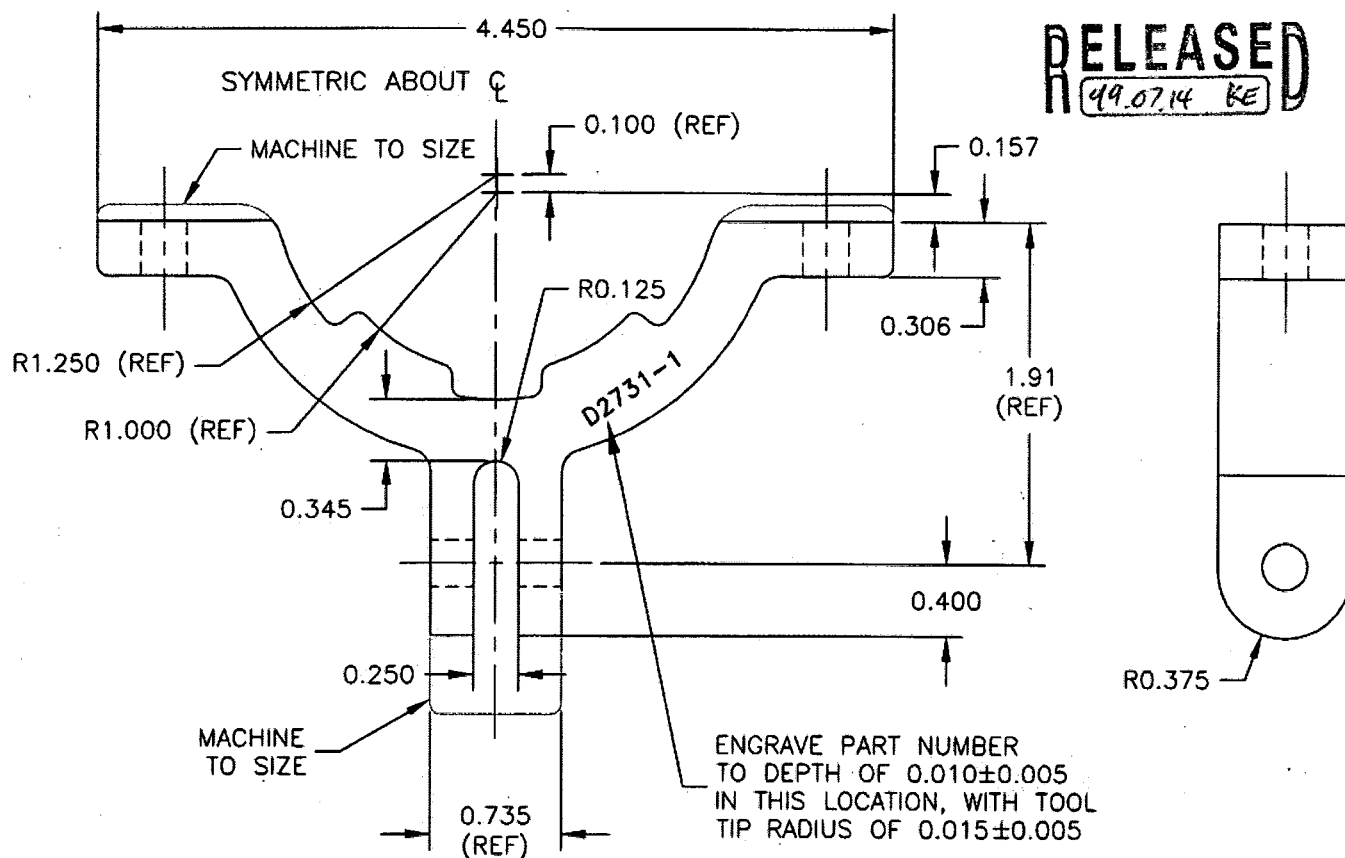
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

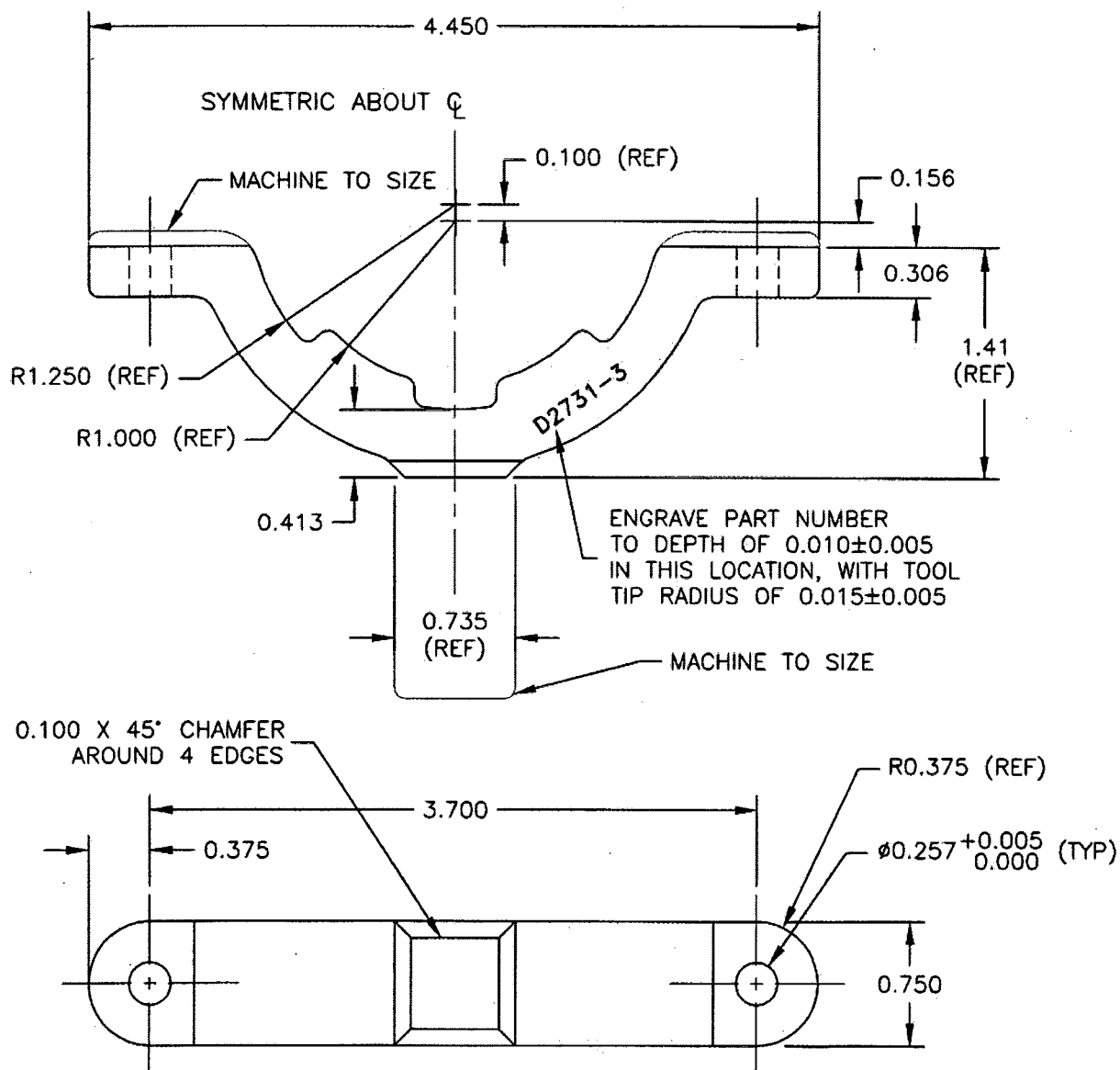


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 WITHOUT NOTICE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN KE	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.07.14 KE



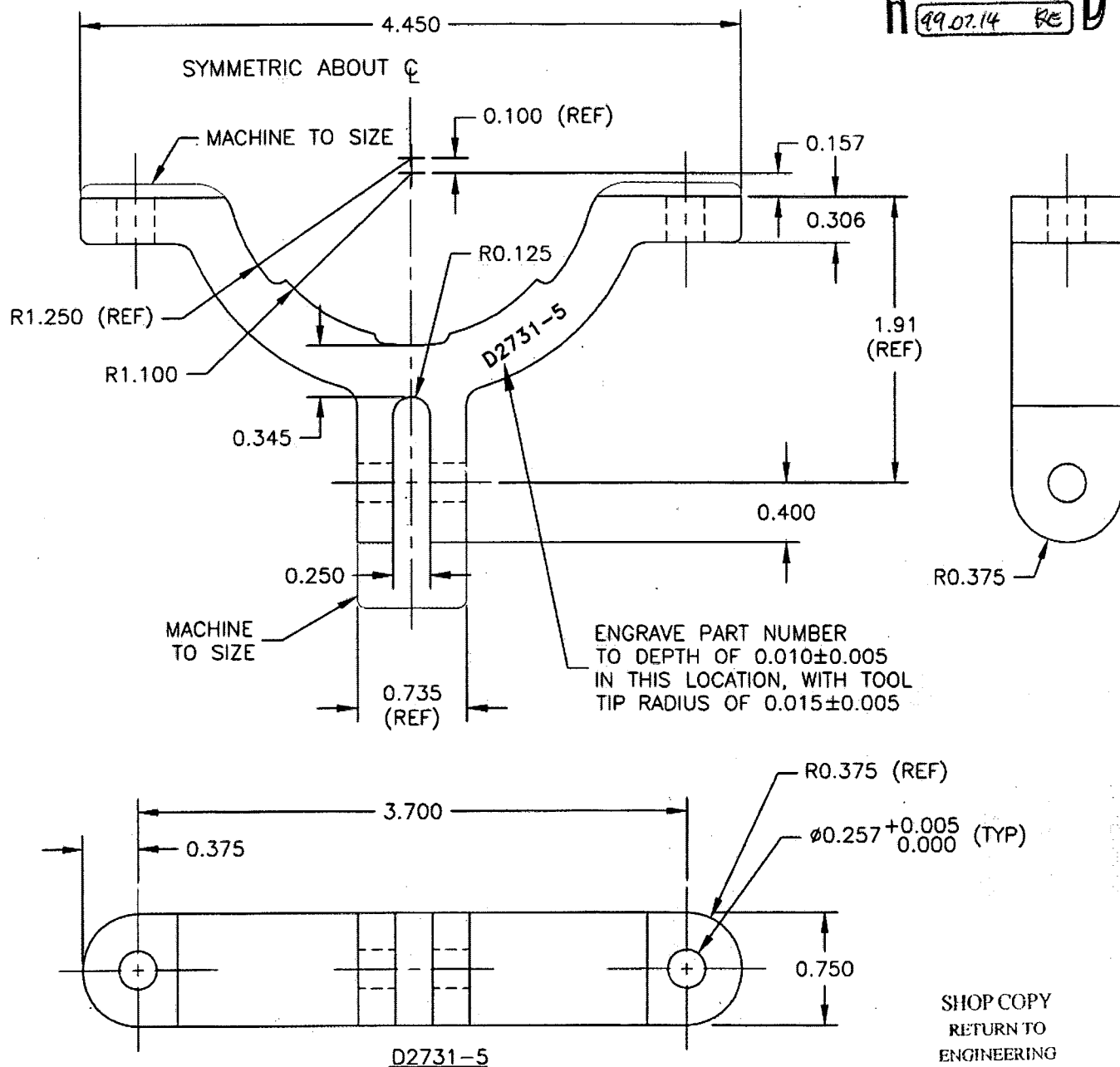
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43313



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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *RE*



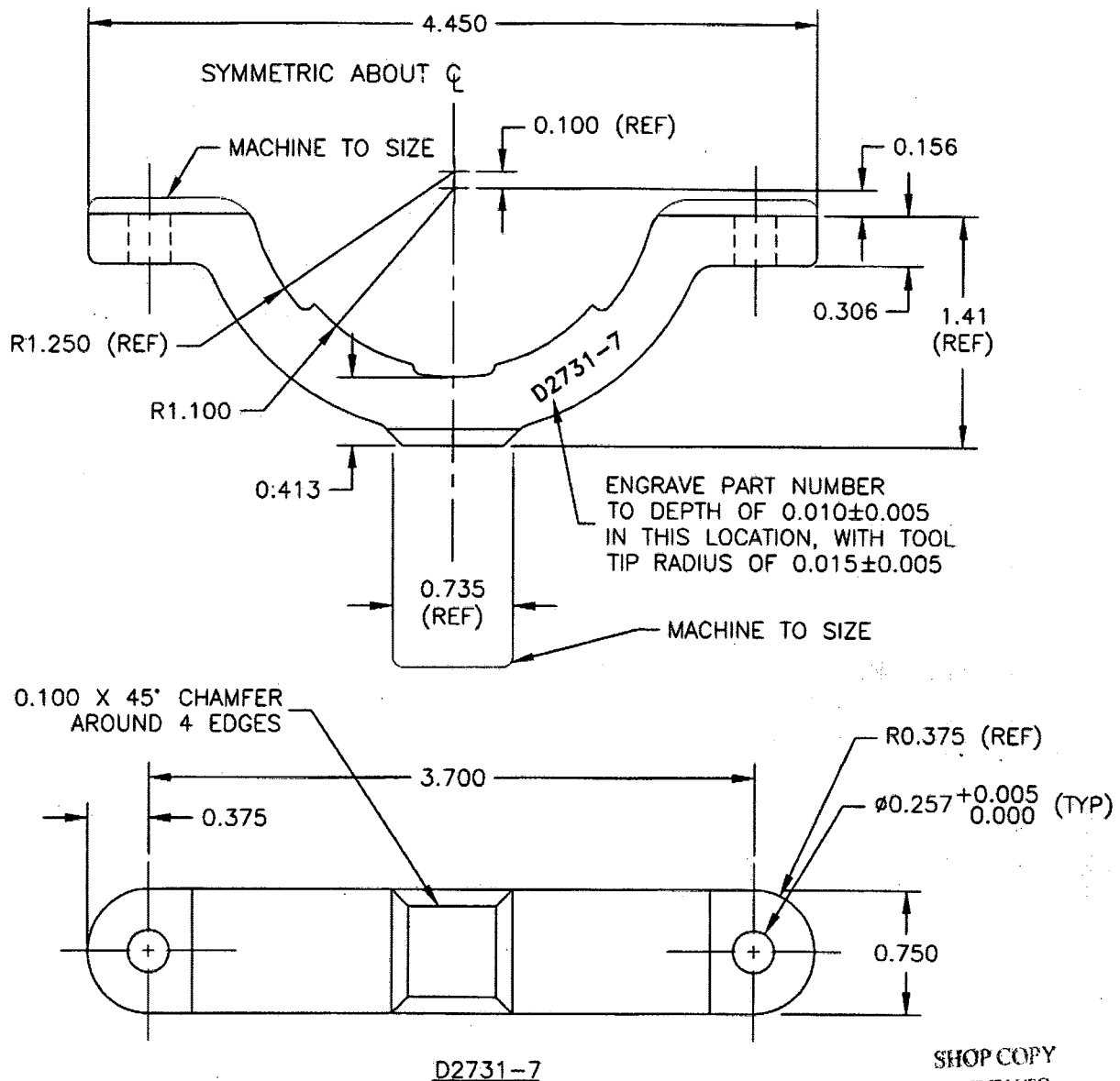
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WORK ORDER

NO. 43313

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
51	D2731-3	Mounting Lug	7572

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Denise Robinson", with a long horizontal line extending to the right.

Denise Robinson

A handwritten signature in black ink, appearing to read "S. Orlovsky", written vertically.

Vankleek Hill, January 8, 2009